

Work Order ID 81986

81986

Page 1

March-21-12 1:55:37 PM

Item ID: D206-642-311 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube LH
 Start Date: 21/03/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 04/04/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *MLJ* Date: *12/03/21* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	O								

100 DOCUMENT CONTROL 0.00
100
 DC Memo 0.00
 Document Control Photocopy bluefile and create labels per PPP D206-642-311 CHG006 *Scrk/22* *MLJ 12/04/12*

110 Pick Kit 0.00
110
 Packaging Memo 0.00
 Packaging *R144/11/11*

120 QC4- 100% Inspect kits for completeness 0.00
120
 QC Memo 0.00
 Quality Control *Scrk/22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81986

81986

Page 2

March-21-12 1:55:37 PM

Item ID: D206-642-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH

Start Date: 21/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-311

Location: 82

PPP Rev: P2

10 82
12-04-27

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

115 12/04/30

115-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

March-21-12 1:55:41 PM

Page 1

Work Order ID: 81986

81986

Parent Item: D206-642-311

D206-642-311

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J05.10.11Added D3429-1 per CHG004KJ/CP/JLM/EC
IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
IPP Rev:L 08-09-29 as per DS19421 DD verified by:EC IPP Rev:M
as per REV.N DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-341		Manufactured	No			110	Each	3.0000	1	1			
D206-642-341									**				
Replacement Skidtube													

Location	Loc Qty	Loc Code
FG081	1	
57156	0	
57160	0	
57161	0	
69950	1	
FG082	2	
36550	1	
69952	1	

D206-648-013

Manufactured No

110 Each

21.0000

1

1

D206-648-013

GHW Modification

**

Location	Loc Qty	Loc Code
FG	5	
78875	5	
FG120	12	
65455	0	
66633	0	
81332	12	
FG125	4	
78874	4	

81986

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

March-21-12 1:55:41 PM

Page 2

Work Order ID: 81986

81986

Parent Item: D206-642-311

D206-642-311

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2932-1

Manufactured No

110

Each

16.0000

1

1

**

D2932-1

Saddle LH Out, 206

Location

Loc Qty

Loc Code

ST421

4

79223

4

ST428

12

73466

2

~~75096~~

6

78968

4

75096

D2933-1

Manufactured No

110

Each

11.0000

1

1

**

D2933-1

Saddle LH In, 206

Location

Loc Qty

Loc Code

ST421

10

74603

6

~~79226~~

4

ST428

1

76191

1

74603

D2938-1

Manufactured No

110

Each

18.0000

1

1

**

D2938-1

Saddle LH Out, 206

Location

Loc Qty

Loc Code

ST421

4

79228

4

ST428A

14

74605

3

75098

5

~~78957~~

6

75098

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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March-21-12 1:55:41 PM

Work Order ID: 81986

81986

Parent Item: D206-642-311

D206-642-311

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2939-1

Manufactured No

110

Each

18.0000

1

1

**

D2939-1

Saddle LH In, 206

Location

Loc Qty

Loc Code

ST421

4

79230

4

ST428A

14

74607

6

75099

2

78956

6

Purchased

No

110

Each

435.0000

8

8

**

AN3-41A

AN3-41A

Bolt

Location

Loc Qty

Loc Code

ST335

235

120644

235

ST354

200

120498

200

Manufactured

No

110

Each

628.0000

16

16

**

D2652

D2652

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

584

73834

15

73836

36

76134

1

76136

55

77134

400

77136

77

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

March-21-12 1:55:41 PM

Page 4

Work Order ID: 81986

81986

Parent Item: D206-642-311

D206-642-311

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,923.000

8

8

**

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

2923

117441

16

117885

32

118451

5

118927

3

119017

2694

119075

173

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

8

8

**

AN960JD10

Washer

AN5-10A

Purchased

No

110

Each

378.0000

4

4

**

AN5-10A

Bolt

Location

Loc Qty

Loc Code

ST337

378

118191

80

120630

50

120717

50

120770

198

AN5-12A

Purchased

No

110

Each

46.0000

4

4

**

AN5-12A

Bolt

Location

Loc Qty

Loc Code

ST338

46

117313

46

March-21-12 1:55:41 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

March 21-12 1:55:41 PM

Page 5

Work Order ID: 81986

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

81986

D206-642-311

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-11A Purchased No

110 Each 733.0000 8 8

AN5-11A

Bolt

**

Location

Loc Qty

Loc Code

ST337

733

118191

13

119512

720

110 Each 0.0000 8 8

AN960JD516

NAS1149D0563J

Purchased

No

AN960.ID516

Washer

**

AN4-6A

Purchased

No

110 Each 1,579.000 12 12

AN4-6A

Bolt

**

Location

Loc Qty

Loc Code

ST356

1579

119017

1579

110 Each 14.0000 24 24

AN960JD416

NAS1149D0463J

Purchased

No

AN960.ID416

Washer

**

Location

Loc Qty

Loc Code

ST351

14

116289

14

110 Each 4,967.000 12 12

MS21042L4

Purchased

No

MS21042L4

Nut

**

Location

Loc Qty

Loc Code

ST300

4967

118451

97

119017

16

119075

2854

121011

2000

March-21-12 1:55:41 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

March 21-12 1:55:41 PM

Page 6

Work Order ID: 81986

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

81986

D206-642-311

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110

Each

39.0000

1

1

**

D3407-043

Tow Ring

Location

Loc Qty

Loc Code

ST420

13

79232

13

ST463

26

68339

2

74519

9

78841

15

78841

D3456-1

Manufactured No

110

Each

70.0000

1

1

**

D3456-1

Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST034

8

77486

8

ST044

55

66848

3

71165

2

80252

50

80252

D3457-1

Manufactured No

110

Each

51.0000

2

2

**

D3457-1

Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST044

41

67779

1

78801

40

78801

March-21-12 1:55:42 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 1:55:42 PM

Page 7

Work Order ID: 81986

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

81986

D206-642-311

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,095.000

1

1

MS21043-4

Nut

**

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1055

119546

370

120308

685

120308

AN4C5A

Purchased

No

110

Each

257.0000

1

1

AN4C5A

BOLT

**

Location

Loc Qty

Loc Code

ST355

257

112243

157

119017

100

119017

AN960C416

NAS1149C0463
R

Purchased

No

110

Each

0.0000

1

1

AN960C416

washer

D3413-1

Manufactured

No

110

Each

72.0000

1

1

D3413-1

Ring

**

Location

Loc Qty

Loc Code

ST420

17

70773

1

79233

16

ST464

55

76754

33

80224

22

76754

March-21-12 1:55:42 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

March-21-12 1:55:42 PM

Page 8

Work Order ID: 81986

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

81986

D206-642-311

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2712

Manufactured No

110

Each

762.0000

10

10

**

D2712

Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST017

500

79585

500

ST021

212

76065

212

76065

Manufactured No

110

Each

80.0000

2

2

**

D2934

D2934

Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31929

6

ST021

74

74883

20

78802

54

78802

Manufactured No

110

Each

108.0000

2

2

**

D2935

D2935

Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31793

6

ST021

102

74882

18

78807

84

78807

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -347	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-347	WEARSHOE KIT (REPLACES -343)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D3535-11	WEARSHOE (REPLACES D2656-11)
22B					1	1				D3536-11	GASKET
23A					1	1				D3535-23	WEARSHOE (REPLACES D2656-23)
23B					1	1				D3536-23	GASKET
24A					1	1				D3535-35	WEARSHOE (REPLACES D2656-35)
24B					1	1				D3536-35	GASKET
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1	1	1						D3456-1	WASHER
32	1	1	1	1						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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Revision: 0

Date: 11.06.15

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D206-642

Page 30 of 43

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -347	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
50							1	1		D4364-041	FWD WEARPLATE ASSY
51							1	1		D4364-043	AFT WEARPLATE ASSY
52							18	18		D3873-1	BUSHING
53							4			D2649	SPACER
54A							9	9		AN3-36A	BOLT
54B							9	9		NAS1149C0332R	WASHER (OR AN960C10L)
54C							9	9		MS21042-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D2650-5 OR D4361-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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